

Work Order ID 65943

Thursday, January 27, 2011 1:14:27 PM



Page 1

Item ID: D4017-041

Accept



Setup Start



Revision ID:

Item Name: Short Basket Base Assembly (350)

Stop



Start Date: 1/28/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 2/14/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: UMF

Date: 11-01-27 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4017

C

100



Large Fab

Large Fab

Weld per dwg A/R S.S. rod Batch: 111585 0.00
Large Fab

Memo

0.00

1- assemble ribs , weld as per dwg D4017 using DT9610B
inspect before welding mesh
2- tack weld mesh on basket as per dwg D4017 and trim mesh to fit if necessary
and trim to clear fasteners holes on the ends
3- weld hinge (3) and Mounting brackets as per dwg D4017
take lid to locate hinge and bracket

11/02/03

11-02-03

11-02-03

110



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds 0.00

Memo

0.00

11/02/07

61.794

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

8.402107

(+1)

Quality Control

125

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

1 BR 11-02-7

Hand Finishing

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Powdercoat

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00

Memo

0.00

1- Plug holes and mask only interior of hinge (3) prior to powder coat

1115951.
1ST COAT:

START TIME: 1:50

OVEN TEMPERATURE: 400°

FINISH TIME: 2:20

*****2nd coat if necessary*****

2ND COAT:

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

1 11-02-7

140



QC

Quality Control

QC3- Inspect Part Finish

0.00

=7

Memo

0.00

1 11-02-4

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Assemble as per dwg

0.00



HandFinish

Memo

0.00

Hand Finishing

JH 11/02/08

1 0

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

S 11/02/08

70

170

Identify as per dwg & Stock Location:

0.00



Packaging

used on w/o 65607

Memo

0.00

Packaging

D4032-041

1 0 JH 11/02/08

W/O:		WORK ORDER CHANGES					
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Required Date: 2/14/2011 Req'd Qty: 1.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/02/08 [Signature]
MF
11-02-08

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Picklist Print

Thursday, January 27, 2011 1:14:24 PM

Page 1

Work Order ID: 65943

Parent Item: D4017-041

Parent Item Name: Short Basket Base Assembly (350)

Start Date: 1/28/2011

Required Date: 2/14/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: new issue DD 09.11.30 verified by:EC IPP Rev:B as per dwg RevA DD 10.03.06 verified by:EC IPP Rev:C as per dwg RevB DD 10.04.16 verified by:EC IPP Rev:D as per dwg revC DD 10.08.18 verified by:EC IPP Rev:E 10.11.04 added pressure wash DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

✓ D4017-1 Rib		Manufactured	No			100	Each	3.0000	1	1		11/02/01	
------------------	--	--------------	----	--	--	-----	------	--------	---	---	--	----------	--

Location

Loc Qty

Loc Code

WA

3

65385

3

* D4017-3 Rib		Manufactured	No			100	Each	0.0000	1	1		11/02/01	
------------------	--	--------------	----	--	--	-----	------	--------	---	---	--	----------	--

✓ D4017-5 Hinge Rib		Manufactured	No			100	Each	0.0000	1	1		11/02/01	
------------------------	--	--------------	----	--	--	-----	------	--------	---	---	--	----------	--

✓ D4017-7 Rib		Manufactured	No			100	Each	8.0000	1	1		11/02/01	
------------------	--	--------------	----	--	--	-----	------	--------	---	---	--	----------	--

Location

Loc Qty

Loc Code

WA

8

58929

2

64681

3

65850

3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 2

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Parent Item: D4017-041

Parent Item Name: Short Basket Base Assembly (350)

Start Date: 1/28/2011

Required Date: 2/14/2011

Start Qty: 1.00

Required Qty: 1.00

✓ D4017-9



Rib

Manufactured No

100

Each

4.0000

2



2

11/02/01

Location

Loc Qty

Loc Code

WA

4

64682

4

✓ D3916-041



Rib Assembly

Manufactured No

100

Each

6.0000

2



2x

11/02/01

Location

Loc Qty

Loc Code

WA

6

64901

6

✓ D3916-5



Light Rib

Manufactured No

100

Each

7.0000

1



2x

11/02/01

Location

Loc Qty

Loc Code

WA

7

57023

1

64167

6

✓ D4034-041



Aft Upper Rib Assembly

Manufactured No

100

Each

0.0000

1



1x

11/02/01

✓ D4034-043



Fwd Upper Rib Assembly

Manufactured No

100

Each

0.0000

1



1

11/02/01

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Shop Packet Print

Page 2

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Page 3

Work Order ID: 65943



Parent Item: D4017-041



Parent Item Name: Short Basket Base Assembly (350)

Start Date: 1/28/2011

Required Date: 2/14/2011

Start Qty: 1.00

Required Qty: 1.00

✓ D2581

Manufactured No

100 Each

29.0000

2

2



Mounting Bracket



Handwritten: 11/02/01

Location

Loc Qty

Loc Code

WA

29

64112

20

64425

9

Handwritten: 2x

D3913-15

Manufactured No

100 Each

11.0000

1

1



Wide Handle Plate



Handwritten: 11/02/01

Location

Loc Qty

Loc Code

WA

11

63627

1

64900

4

65851

6

Handwritten: 1x

✓ D4016-1

Manufactured No

100 Each

10.0000

3

3



Hinge Half, Base



Handwritten: 11/02/01

Location

Loc Qty

Loc Code

WA

10

64264

1

65374

9

Handwritten: 3x

✓ D4020-3

Manufactured No

100 Each

0.0000

1



Mesh (350 Basket Short, Base)



Handwritten: B65907 → ① 11-02-02

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Shop Packet Print

Page 3

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Page 4

Work Order ID: 65943

Parent Item: D4017-041

Parent Item Name: Short Basket Base Assembly (350)

Start Date: 1/28/2011

Required Date: 2/14/2011

Start Qty: 1.00

Required Qty: 1.00

D4020-11

Manufactured No

100

Each

8.0000

2



End Mesh, Basket

Location

Loc Qty

Loc Code

WA

8

59413

1

61306

1

64923

6



2
11/02/02

D2931

Manufactured No

150

Each

734.0000

2



Bumper

Location

Loc Qty

Loc Code

ST504

734

46064

734



2
11/2/7sf

D4021-1

Manufactured No

100

Each

27.0000

3



Handle Plate

Location

Loc Qty

Loc Code

ST109

5

57086

5

WA

22

64136

1

64903

9

65848

12



3
11/02/01

D4021-5

Manufactured No

150

Each

8.0000

2



Blanking Plate

Location

Loc Qty

Loc Code

ST112

8

64243

8



2
11/2/7sf

2

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Page 4

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Page 5

Work Order ID: 65943

Parent Item: D4017-041

Parent Item Name: Short Basket Base Assembly (350)

Start Date: 1/28/2011

Required Date: 2/14/2011

Start Qty: 1.00

Required Qty: 1.00

AN3-10A Purchased No

150

Each

117.0000

6



Bolt



1/12/78

Location

Loc Qty

Loc Code

ST351

117

115877

1

116075

16

116400

100

AN960JD8 NAS1149DN832J Purchased No

150

Each

10.0000

2



Washer



2

11168005 1/12/78

Location

Loc Qty

Loc Code

ST347

10

105059

10

MS20600-AD4W3 Purchased No

150

Each

1,335.000

2



Cherry Rivets



2

1/12/78

Location

Loc Qty

Loc Code

ST321

1335

107939

754

111636

581

MS21042L3 Purchased No

150

Each

3,053.000

6



Nut



6

1/12/78

Location

Loc Qty

Loc Code

ST300

3053

114784

9

115835

544

116391

900

116540

800

116549

800

Thursday, January 27, 2011 1:14:25 PM

Shop Packet Print

Page 5

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Parent Item Name: Short Basket Base Assembly (350)

Start Date: 1/28/2011

Required Date: 2/14/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1149F0332P

Purchased

No

150

Each

278.0000

12

12



WASHER

11/2/12sf

Location

Loc Qty

Loc Code

ST275

278

18057

278

12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

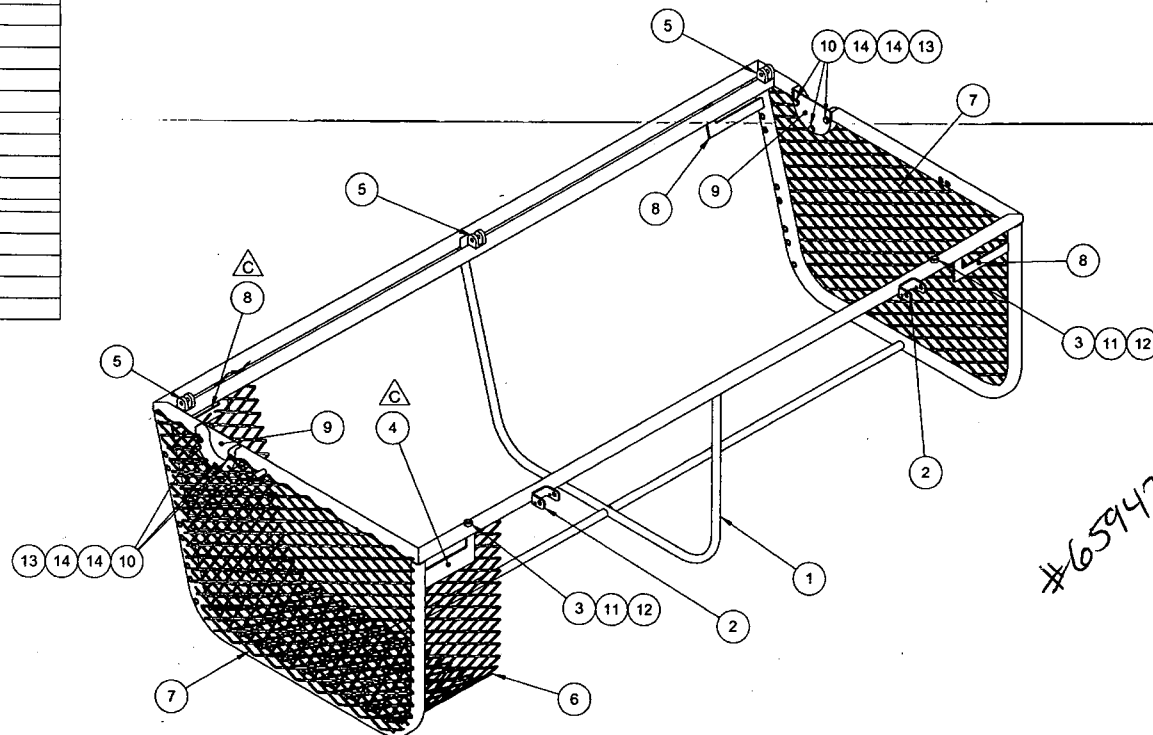
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ITEM	QTY	P/N	DESCRIPTION
	X	D4017-041	SHORT BASKET BASE ASSY (350)
1	1	D4017-101	TUBULAR ASSY (350 SHORT BASKET)
2	2	D2581	MOUNTING BRACKET
3	2	D2931	BUMPER
4	1	D3913-15	WIDE HANDLE PLATE
5	3	D4016-1	HINGE HALF, BASE
6	1	D4020-3	MESH (350 BASKET SHORT BASE)
7	2	D4020-11	END MESH, BASKET
8	3	D4021-1	HANDLE PLATE
9	2	D4021-5	BLANKING PLATE
10	6	AN3-10A	BOLT
11	2	AN960JD8	WASHER
12	2	MS20600AD4W3	RIVET
13	6	MS21042L3	NUT
14	12	NAS1149F0332P	WASHER



D4017-041 SHORT BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

ECN 10-596
RELEASED
10.06.12

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 28.8 lbs APPROX
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) WELD PER DART QSI 004

C	ITEM #4 NOW INSTALLED OUTBOARD (C4-1, C5-1, B5-2 AND D6-2). REASON: ELIMINATE INTERFERENCE PREVENTING INSTALLATION OF RECEIVER ASSEMBLIES.	MB	10.07.23
B	QTY 1 D4021-1 REPLACED WITH QTY 1 D3913-15; AN3-10A BOLT WAS AN3C10A; NAS1149F0332P WASHER WAS NAS1149C0332R; SECTION F-F UPDATED (D6-2); ITEMS RENUMBERED; DETAIL D UPDATED (A4-3)	JPH	10.03.25
A	NEW ISSUE	AJS	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	ALJ	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JP		
CHECKED	JP	DRAWING NO.	REV. C
MFG. APPR.	J.F.S.	D4017	SHEET 1 OF 5
APPROVED	WJ	TITLE	SCALE
DE APPR.	WJ	SHORT BASKET BASE ASSY (350) _NTS	
DATE	10.07.23	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

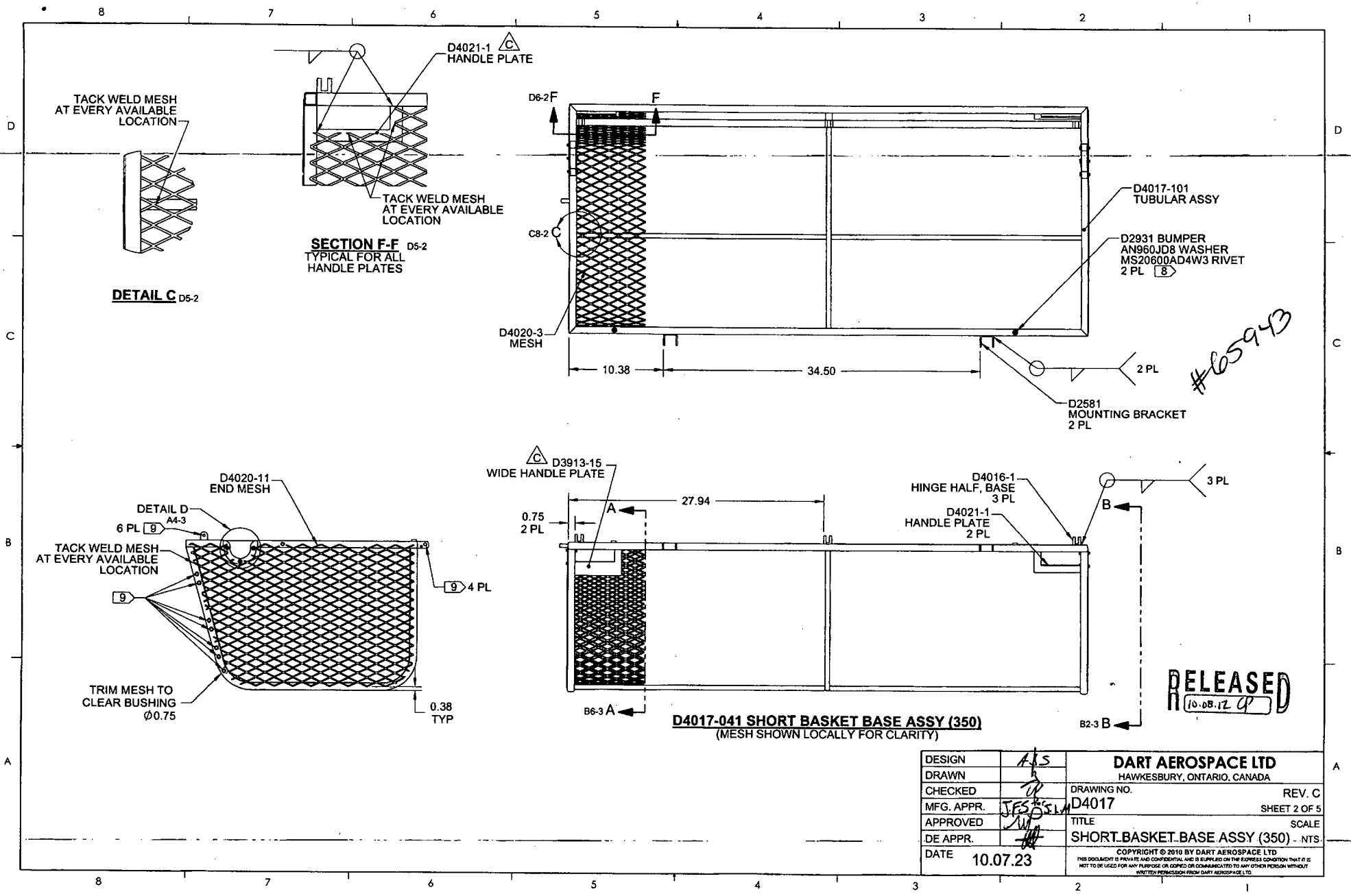
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D4017-041 SHORT BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN	JP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JES	DRAWING NO.	REV. C
MFG. APPR.	JES	D4017	SHEET 2 OF 5
APPROVED	JW	TITLE	SCALE
DE APPR.	JW	SHORT.BASKET.BASE ASSY (350) - NTS.	
DATE	10.07.23	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

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8 7 6 5 4 3 2 1

D

D

C

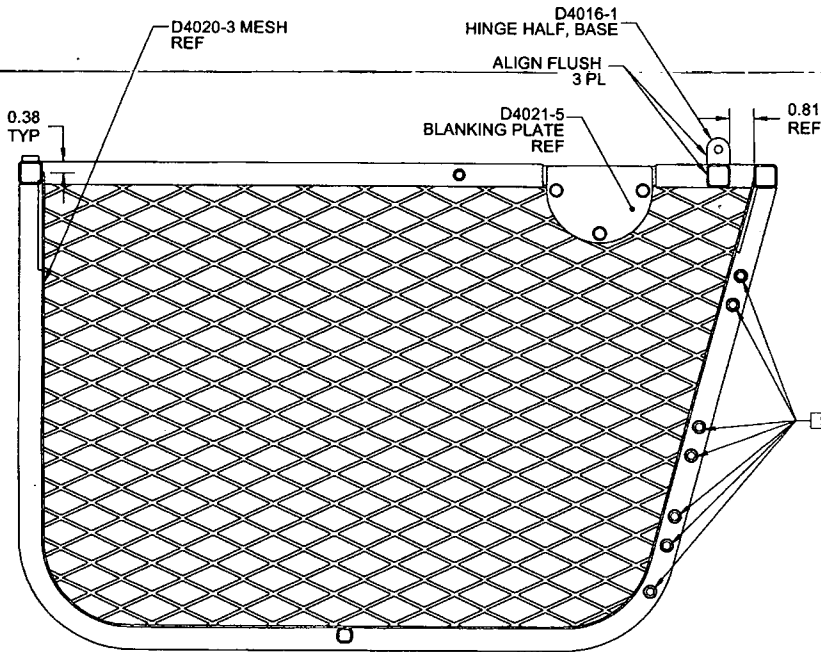
C

B

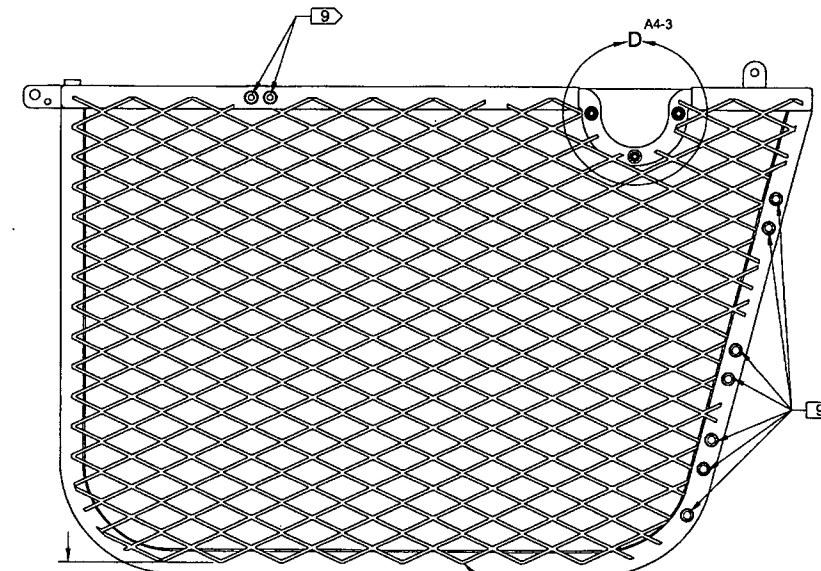
B

A

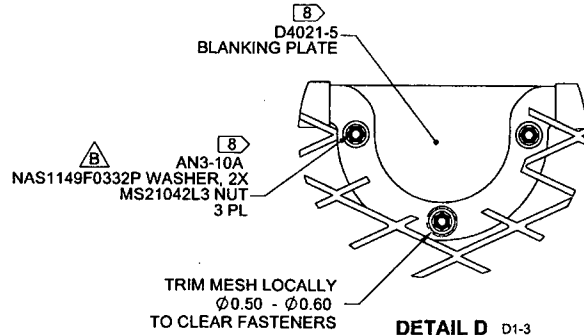
A



SECTION A-A A5-2



SECTION B-B A2-2



DETAIL D D1-3 B8-2

#65943

RELEASED
10-08-12 4

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	JFS	DRAWING NO. D4017	REV. C
MFG. APPR.	JFS		SHEET 3 OF 5
APPROVED	JM	TITLE	SCALE
DE APPR.		SHORT-BASKET-BASE ASSY (350) -NTS-	
DATE	10.07.23	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

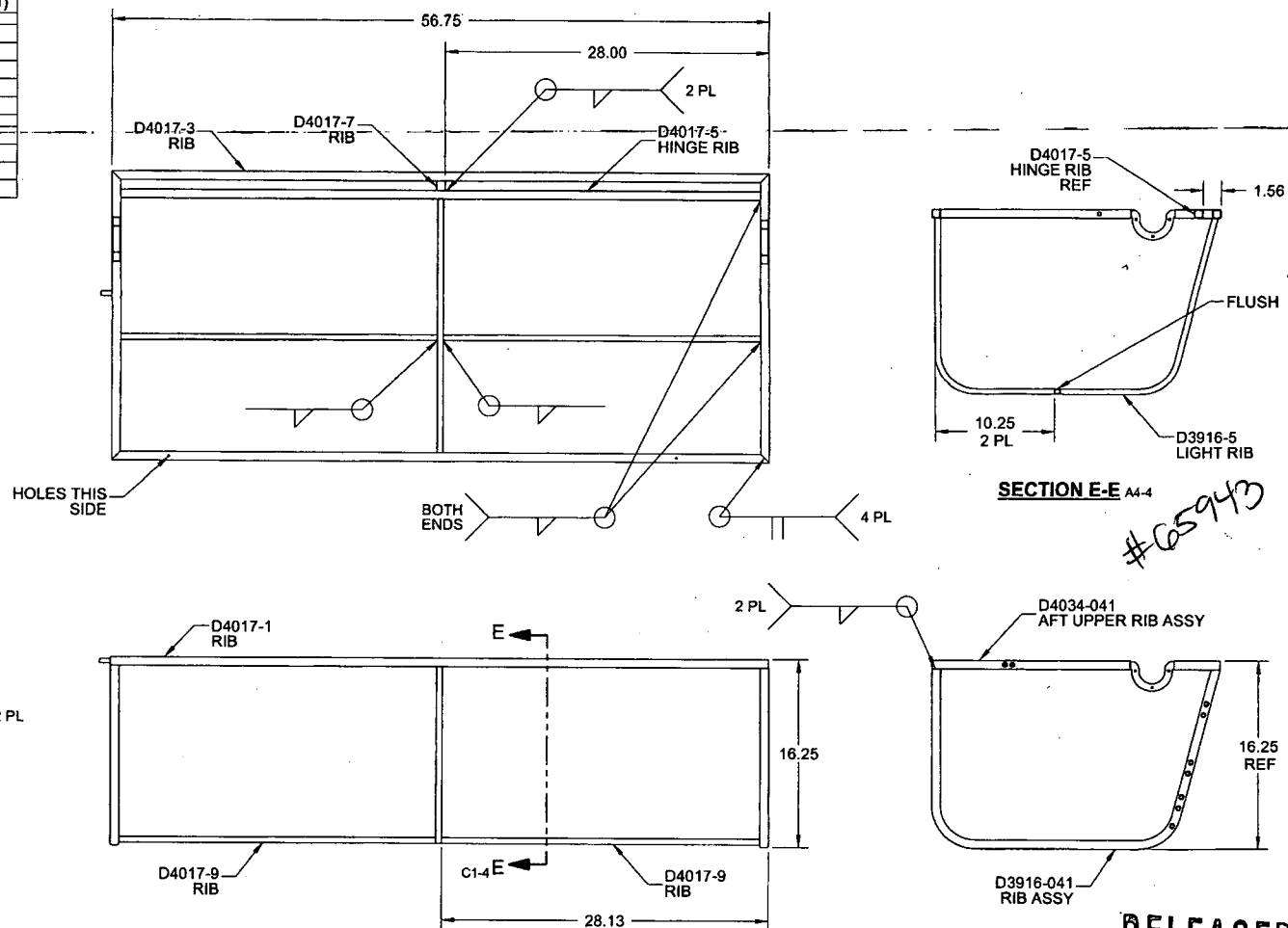
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -101	P/N	DESCRIPTION
	X	D4017-101	TUBULAR ASSY (350 SHORT BASKET)
1	1	D4017-1	RIB
2	1	D4017-3	RIB
3	1	D4017-5	HINGE RIB
4	1	D4017-7	RIB
5	2	D4017-9	RIB
6	2	D3916-041	RIB ASSY
7	1	D3916-5	LIGHT RIB
8	1	D4034-041	AFT UPPER RIB ASSY
9	1	D4034-043	FWD UPPER RIB ASSY



- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 15.26 lbs
 - 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D4017-101
 - 9) WELD PER DART QSI 004

8 D4017-101 TUBULAR ASSY (350 SHORT BASKET)

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN	JP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO. D4017	REV. C
MFG. APPR.	SY5.3.1.1		SHEET 4 OF 5
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	SHORT BASKET-BASE ASSY (350)	NTS
DATE	10.07.23	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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10.08.12

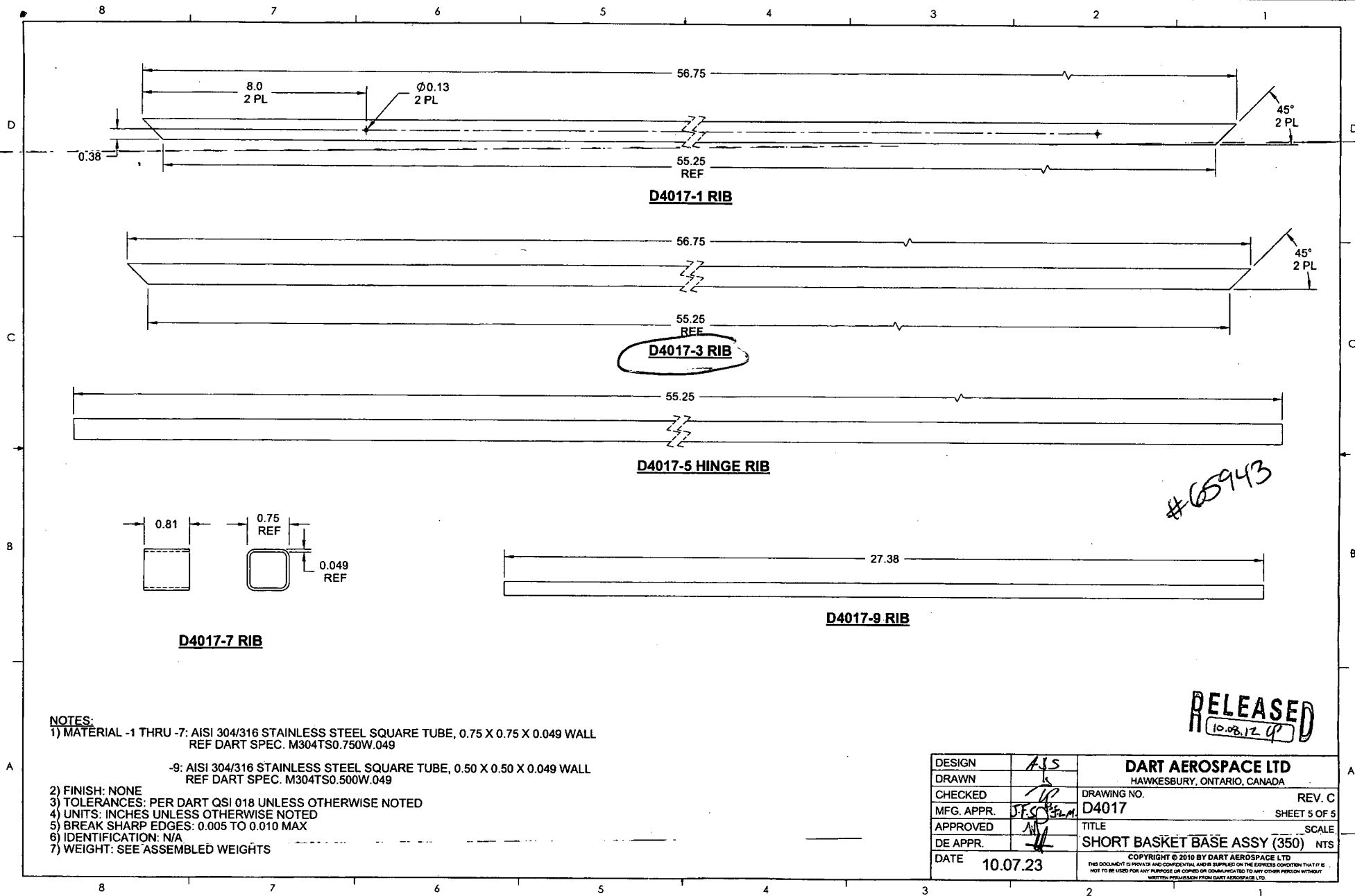
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries